PROJECT TITLE : QA ANALYTICAL SERVICES

PERIOD COVERED : APRIL 29 - MAY 20 1981

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3.2.1. TRIALS WITH NEW SUPPLIES OF TOBACCO INGREDIENTS

- Diethylene glycol (PMG Berlin) (Ref. 1)

  Two industrial trials on MLK-DB - cigarettes were organized with products from BASF and BAYER.

  Smoking Analyses: No significant differences were found between the standard and the trials.

  Subjective evaluation (Panel A): A singificant difference between the standard and the trials was found. The trial with diethylene glycol from BASF was considered to be better than the standard and the trial with diethylene glycol from BAYER.

  In order to confirm this result a second industrial trial with the material from BASF will be organized by PMG Berlin.

- Licorice in blocks (Ref. 2)

  The two samples (PREZIA, Siderno(Italy) and FICHERA, Catania(Italy))corresponded to our specifications.

- Flavour 153 (SFC 153) (PMI, New York/yellow sheet 5944, 1000 kg) (Ref. 3)

  A subjective evaluation (check) was organized on the first industrial production with this flavour on BSD, MAH and MER cigarettes.

  No significant difference to the standards was found. Concluded on 11/05/81

3.2.2. QUALITY CONTROL OF TOBACCO INGREDIENTS

- Honey (SCHUETTE & CO, Bremen (Germany)/blue sheet 8552, 10000 kg)

  Important differences as regards the colour of the contents from one drum to the other were observed.

  17 drums out of 34 were blocked because of the dark brown or black colour. Chemical analyses (sugar and water - contents) were within specifications.

  Hydroxy methyl furfural (HMF) was determined in five samples of the blocked drums. The HMF-value gives an indication as to whether any adulteration by invert sugar has been done, or whether the honey was overheated.

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Values between 6.5 up to 122 mg HMF/100 g honey were found. The higher this value became, the darker was the sample.

In a reference sample a value of 3.8 mg/100 g was found.

On the basis of these results the 17 drums in question were returned to the supplier.

3.4.1. TRIALS WITH NEW SUPPLIES OF FILTER COMPONENTS

- Activated Charcoal (H. FORRER SA, Zollikon (CH); NESS (GB) / yellow sheet 6014, 2 x 500 g)

  Two qualities were submitted. The quality "CK 830" was largely out of specifications as regards the CCl_4-index (42.2 % !).

  The quality "CC 1230 M" was slightly out of specifications as regards CCl_4-index (58.8 %) and granulometry (3.2 % on the sieve of 14 Mesh).

  A meeting between Quality Assurance and a representative of this supplier will be organized in order to discuss the results.

3.5.1. TRIALS WITH NEW SUPPLIES OF FILTER GLUES

- Hot Melt for filter rod seam (DELFT CHEMIE SA, Winterthur; "CIE LOK 80 / 234 - 2980" / yellow sheet 5820, 50 kg and yellow sheet 5943, 50 kg)

  This product is used as a standard glue in PMG and PMH. Two industrial trials on MLF cigarettes were organized.

  Machineability: Identical to the standard glue

  Storage: After two months, no difference between this and the standard glue was observed.

  Smoking analyses: No significant differences between the trials and standards were observed.

  Subjective evaluation (Panel B): In both trials a significant difference between the standard and test-cigarette was found. Both trials were rejected.

  As taste problems in connection with this glue were observed in PMH, the qualification of this supplier will be checked.

- Hot Melt for filter seam ("LUNATACK C 5830" and "LUNATACK C 5316", ex FULLER GmbH)

  An industrial trial on PMS-FR cigarettes was organized by PMG Munich.

  Machineability: "LUNATACK C 5316" gave problems of adhesiveness and was rejected. "LUNATACK C 5830" was identical to the standard glue.

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Storage: The seam of the filter rods with "LUNATACK C 5830" opened already after a couple of days.

Concluded on 18/05/81

- Liquid glue for filter rod seam (W. LAESSER AG, Erlinsbach, "LESSO 1747/83", 25 kg)

The glue application system of a KDF II in Cousset concerning the filter rod seam was modified. Instead of Hot Melt a liquid glue will be applied through a nozzle. An industrial trial on MLF - cigarettes was organized.

Machineability: The glue showed good adhesive properties. However, at a higher machine speed gluing problems were encountered.

Smoking analyses: No significant difference between the trial and the standard was observed.

Subjective evaluation (Panel A) : A significant difference was found between the trial and the standard. The trial was rejected.

Trials will be continued in order to find an acceptable liquid glue.

3.6.1. TRIALS WITH NEW SUPPLIES OF TIPPING GLUES

- "5008/A 33" (ex WIKOLIN) (Ref. 4)

The trial on PMS-FR cigarettes was organized by PMG Munich.

Machineability: Identical to the standard glue.

Smoking analyses: No significant difference between trial and standard was observed.

Subjective evaluation (Panel A): The trial was accepted.

It is planned to organize a long-term test before qualifying this supplier.

- "32 WE 117" (ex FULLER GmbH)

An industrial trial on PMS-FR cigarettes was organized by PMG Munich.

Machineability: Not as good as the standard glue by a long way.

Further trials are not planned.

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3.7.1. TRIALS WITH NEW SUPPLIES OF CIGARETTE SEAM GLUES

- "LESSO 5073" (W. LAESSER, Erlinsbach/yellow sheet 5934, 5 kg)

  This trial on MLF-CH cigarettes was organized within the framework of trials with glues on a PVA-basis. For this glue no special permission was requested from the German authorities.

  Machineability: Better adhesive properties than the standard glue. Comparable with the other glues on a PVA-basis.

  Smoking analyses: No significant difference between standard and trial was observed.

  Subjective evaluation (Panel B): A significant difference between the trial and standard was found. The trial was rejected.

  Further trials are not planned.

- TÜRMERLEIM NAT 5 (JULES HESS, Zürich; ex TÜRMER/yellow sheet 5955, 5 kg) (Ref. 5)

  The glue is in powder form and its basis is starch. The powder has to be dissolved in water and filtered before use. The purpose of the trial was to check if, in the case of the installation of the KAYMICH-System in PM Nigeria, a liquid glue would be available.

  Preparation: No special problems were encountered. The optimal ratio of water and solid was 4 to 1.

  Machineability: The glue was applied without problem under the same conditions as the standard glue. The adhesivity is comparable with that of the maize starch.

  For a possible alternative to the standard glue, in case of difficulties with the latter, a subjective evaluation (Panel B) was organized. However, a significant difference was found. The trial was rejected.

  Further trials are not planned.

3.12. QUALITY CONTROL OF CIGARETTE PAPER

- ECUSTA 11/708 (PMG Munich) Ref. 6)

  The physical analyses showed an insufficient combustibility of this paper possibly due to an incorrect quantity of citric acid.

  Citric acid was determined by HPLC on a "Lichrosorb 10 RP 8" column. An average value of 0.44 % of citric acid monohydrate on five samples was found. This value is within specifications (0.55 % $\pm$ 0.25 %).

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5. SERVICES FOR OTHER GROUPS

- Analyses for foil mentholating
  Menthol in cigarettes (23 samples)

REFERENCES

1. Monthly report Widmer-A (October 1980)
   Monthly report Widmer-A (December 1980)
   Letter from Widmer-A to Reinboldt-W (May 12 1981)
2. Letter from Schwarb-A to Trento-A (April 21 1981)
3. Monthly report Widmer-A (April 1980)
4. Monthly report Widmer-A (April 1980)
   Letter from Widmer-A to Lutzig-B.W. (May 13 1981)
5. Letter from Widmer-A to Lauenstein-M (March 20 1981)
6. Telex from Balliger-P to Lutzig-B.W. (April 6 1981)

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